

Date: Tuesday, 10/06/2008 12:54:58 PM  
 User: Julie Lecocq

## Process Sheet

SPLIT

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: SADDLE KIT		
Job Number	: 39797-1			Part Number	: K10003		
Estimate Number	: 10532			Drawing Number	: K10003		
P.O. Number	:			Project Number	: N/A		
This Issue	: 10/06/2008	S.O. No.	:	Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: MACHINED PARTS	Due Date	: 23/06/2008		
Previous Run	: 39466			Qty:			
Written By	:			Um:	Each		
Checked & Approved By	: JLD 08.6.10						
Comment	: Est : I 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF Est : J 06-07-25 As per DSI 9344 Est : K 06.11.17 Per K10003 Rev C Est : L 07.01.12 Document Record for copying bluefile rmv KJ			JLM			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
		JLD 08.6.10	
		Comment: DOCUMENT CONTROL	
		Create White labels only per PPP K10003	CHG 005
2.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1	
		Pick Packing Kit	
3.0	D2570	Bushing	
		Comment: Qty.: 24.0000 Each(s)/Unit Total : 192.0000 Each(s)	
		Bushing	
		Pick:	
	Qty	Part Number	Description
	24	D2570	Bushing
4.0	D2571	Saddle, Fwd Out 205	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)	
		Saddle, Fwd, Out	
		Pick:	
	Qty	Part Number	Description
	1	D2571	Saddle

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
5.0	D2572	Saddle, Fwd In 205 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Saddle, Fwd, In Pick: Qty 1 Part Number D2572 Description Saddle Batch 39123 B400882XPL8 SV
6.0	D2573	Saddle, Aft Out 205 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Saddle, Aft, Out Pick: Qty 1 Part Number D2573 Description Saddle Batch 38922 SP
7.0	D2574	Saddle, Aft In 205 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Saddle, Aft, In Pick: Qty 1 Part Number D2574 Description Saddle Batch 391809 6 39476 SV 87/7 50
8.0	D27361	Lug Assembly, 205 GHW 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Lug Assembly Pick: Qty 1 Part Number D2736-1 Description Bracket Batch 39064 SP
9.0	D27363	Lug Assembly, 205 GHW 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Lug Assembly Pick: Qty 1 Part Number D2736-3 Description Bracket Batch 38661 39842 7 87/4 SP

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:	Machine Or Operation:	Description :
10.0	D2747	Set Screw

*(Handwritten: X-X-X)*



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Set Screw

Pick:

Qty	Part Number	Description	Batch
4	D2747	Socket Head Set Screw	<i>36331</i>

*25*

*7*

*39797*

*SP*

11.0 D2876 Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Saddle Spacer

Pick:

Qty	Part Number	Description	Batch
2	D2876	Spacer	<i>36275</i>

*16*

12.0 D2877 Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Saddle Spacer

Pick:

Qty	Part Number	Description	Batch
2	D2877	Spacer	<i>34818</i>

*SP*

*SP*

13.0 D2968041 Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Tow Ring

Pick:

Qty	Part Number	Description	Batch
1	D2968-041	Tow Ring	<i>37929</i>

*4*

*SP*

14.0 D35331 Set Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Set Screw

Batch: *28093*

*8x*

*8/7/4*

*SP*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:	Machine Or Operation:	Description :
15.0	AN46A	Bolt
	Comment: Qty.: 16.0000 Each(s)/Unit Total : 128.0000 Each(s)	
	Bolt	
	Pick:	
	Qty 16	Part Number AN4-6A
		Description Bolt
		Batch 107534
16.0	AN446A	Bolt
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)	
	Bolt	
	Pick:	
	Qty 4	Part Number AN4-46A
		Description Bolt
		Batch 107534
17.0	AN451A	Bolt
	Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)	
	Bolt	
	Pick:	
	Qty 8	Part Number AN4-51A
		Description Bolt
		Batch 107755
		60
		108077
18.0	AN612A	Bolt
	Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)	
	Bolt	
	Pick:	
	Qty 8	Part Number AN6-12A
		Description Bolt
		Batch 107178
		53
		107823
19.0	AN960JD416	Washer
	Comment: Qty.: 32.0000 Each(s)/Unit Total : 256.0000 Each(s)	
	Washer	
	Pick:	
	Qty 32	Part Number AN960JD416
		Description Washer
		Batch 103691
		26
		10/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN960JD616

Washer

Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Washer

Pick:

Qty 8

Part Number AN960JD616

Description Washer

Batch 107242

SP

21.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Pick:

Qty 1

Part Number AN970-4

Description Washer

Batch 108077

SP

22.0

MS21042L4

Nut



8/1/3

(8x)

Comment: Qty.: 29.0000 Each(s)/Unit Total : 232.0000 Each(s)

Nut

Pick:

Qty 29

Part Number MS21042L4

Description Nut (or MS21042-4)

Batch 102552

107478



SP

23.0

QC4

INSPECT 100% KITS FOR COMPLETENESS

Comment: INSPECT KITS 100% FOR COMPLETENESS

24.0 PACKAGING 1

PACKAGING RESOURCE #1



(8x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: H

8/1/18 (4)

25.0 QC21

FINAL INSPECTION/W/O RELEASE



08/07/18 (4)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



8/07/18

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 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**DART**

DESIGN <i>A</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>JH</i>	DRAWING NO. K10003	REV. C SHEET 1 OF 1
DATE 06.11.07	TITLE SADDLE KIT		SCALE NTS
A	00.06.01	NEW ISSUE	
B	00.11.22	ADD D2707-041 OPTION	
C	06.11.07	ADD D3533-1	

RELEASED

06.11.07 *H*

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 205/210/212/412	D205-634-011 D205-634-015
BELL 204	D204-635-011

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

PART NUMBER	K10003	D205-634-011 D205-634-015	D204-635-011
D205-641-011	1	1	1
D2570	16	16	16
D2571	1	1	1
D2572	1	1	1
D2573	1	1	1
D2574	1	1	1
D2747	4	4	4
D2876	2	2	2
D2877	2	2	2
D2707-041 (or D2968-041)	1	1	1
D3533-1	2	2	2
AN4-51A	8	8	8
AN4-6A	16	16	16
AN6-12A	8	8	8
AN960JD416	32	32	32
AN960JD616	8	8	8
*AN960JD1016	1	1	1
AN970-4	1	1	1
MS21042-4 (OR L4)	25	25	25

\* REQUIRED WITH D2707-041 ONLY

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WITHOUT NOTICE WORK ORDER  
NO. 391971

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